

Work Order ID 53337

October 30, 2009 1:33:18 PM

Page 1

Item ID: PB67-43001-173

Accept

Revision ID: ~~B1 C 72544~~ 09.12.09

Item Name: Cover Plate

Start Date: 11/2/2009 Start Qty: 10.00

Required Date: 11/23/2009 Req'd Qty: 10.00

Reference:

Cust Item ID:

Customer:

Setup Start

Stop

Run Start

Stop

Approvals: Process Plan: MF Date: 09-10-30 Tooling:

Date:

QC: Date: SPC (Y/N):

Date:

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

B67-43001

Rev B1

FLOW WATER JET

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg B67-43001 ☐ Dwg Rev: C ☐ Prog Rev: C☐\*\*\*\*grain direction along 7.065" \*\*\*\* ☐ 2-Deburr if necessary

0.00

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

110



QC

Quality Control

0.00

QC8- Inspect parts - second check

0.00

Memo

120



QC

Quality Control

MINIARY ISSUE

B 9-12-17

B 9-12-17

M-1 09/12/18 (12X) 12

(42)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

1. The first step in the process is to identify the problem or issue that needs to be addressed. This involves gathering information and understanding the context of the problem.

2. Once the problem is identified, the next step is to define the objectives and goals of the project. This helps to clarify what needs to be achieved and provides a clear direction for the team.

3. The third step is to develop a plan or strategy to address the problem. This involves breaking down the problem into smaller, manageable tasks and determining the resources needed to complete each task.

4. The fourth step is to implement the plan. This involves assigning tasks to team members, setting deadlines, and monitoring progress to ensure that the project is on track.

5. The final step is to evaluate the results of the project. This involves comparing the actual outcomes against the objectives and goals to determine the effectiveness of the project and identify areas for improvement.

Page 2

[illegible]

[REDACTED]

[illegible]

1. The first step in the process is to identify the problem or issue that needs to be addressed. This involves gathering information and understanding the context of the problem.

2. Once the problem is identified, the next step is to define the objectives and goals of the project. This helps to clarify what needs to be achieved and provides a clear direction for the team.

3. The third step is to develop a plan or strategy to address the problem. This involves breaking down the problem into smaller, manageable tasks and determining the resources needed to complete each task.

4. The fourth step is to implement the plan. This involves assigning tasks to team members, setting deadlines, and monitoring progress to ensure that the project is on track.

5. The final step is to evaluate the results of the project. This involves comparing the actual outcomes with the objectives and goals to determine the effectiveness of the project and identify areas for improvement.

**Customer:**



**Abstract**

**Insp.  
Stamp**

11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31 32 33 34 35 36 37 38 39 40 41 42 43 44 45 46 47 48 49 50 51 52 53 54 55 56 57 58 59 60 61 62 63 64 65 66 67 68 69 70 71 72 73 74 75 76 77 78 79 80 81 82 83 84 85 86 87 88 89 90 91 92 93 94 95 96 97 98 99 100 101 102 103 104 105 106 107 108 109 110 111 112 113 114 115 116 117 118 119 120 121 122 123 124 125 126 127 128 129 130 131 132 133 134 135 136 137 138 139 140 141 142 143 144 145 146 147 148 149 150 151 152 153 154 155 156 157 158 159 160 161 162 163 164 165 166 167 168 169 170 171 172 173 174 175 176 177 178 179 180 181 182 183 184 185 186 187 188 189 190 191 192 193 194 195 196 197 198 199 200 201 202 203 204 205 206 207 208 209 210 211 212 213 214 215 216 217 218 219 220 221 222 223 224 225 226 227 228 229 230 231 232 233 234 235 236 237 238 239 240 241 242 243 244 245 246 247 248 249 250 251 252 253 254 255 256 257 258 259 260 261 262 263 264 265 266 267 268 269 270 271 272 273 274 275 276 277 278 279 280 281 282 283 284 285 286 287 288 289 290 291 292 293 294 295 296 297 298 299 300 301 302 303 304 305 306 307 308 309 310 311 312 313 314 315 316 317 318 319 320 321 322 323 324 325 326 327 328 329 330 331 332 333 334 335 336 337 338 339 340 341 342 343 344 345 346 347 348 349 350 351 352 353 354 355 356 357 358 359 360 361 362 363 364 365 366 367 368 369 370 371 372 373 374 375 376 377 378 379 380 381 382 383 384 385 386 387 388 389 390 391 392 393 394 395 396 397 398 399 400 401 402 403 404 405 406 407 408 409 410 411 412 413 414 415 416 417 418 419 420 421 422 423 424 425 426 427 428 429 430 431 432 433 434 435 436 437 438 439 440 441 442 443 444 445 446 447 448 449 450 451 452 453 454 455 456 457 458 459 460 461 462 463 464 465 466 467 468 469 470 471 472 473 474 475 476 477 478 479 480 481 482 483 484 485 486 487 488 489 490 491 492 493 494 495 496 497 498 499 500 501 502 503 504 505 506 507 508 509 510 511 512 513 514 515 516 517 518 519 520 521 522 523 524 525 526 527 528 529 530 531 532 533 534 535 536 537 538 539 540 541 542 543 544 545 546 547 548 549 550 551 552 553 554 555 556 557 558 559 560 561 562 563 564 565 566 567 568 569 570 571 572 573 574 575 576 577 578 579 580 581 582 583 584 585 586 587 588 589 590 591 592 593 594 595 596 597 598 599 600 601 602 603 604 605 606 607 608 609 610 611 612 613 614 615 616 617 618 619 620 621 622 623 624 625 626 627 628 629 630 631 632 633 634 635 636 637 638 639 640 641 642 643 644 645 646 647 648 649 650 651 652 653 654 655 656 657 658 659 660 661 662 663 664 665 666 667 668 669 670 671 672 673 674 675 676 677 678 679 680 681 682 683 684 685 686 687 688 689 690 691 692 693 694 695 696 697 698 699 700 701 702 703 704 705 706 707 708 709 710 711 712 713 714 715 716 717 718 719 720 721 722 723 724 725 726 727 728 729 730 731 732 733 734 735 736 737 738 739 740 741 742 743 744 745 746 747 748 749 750 751 752 753 754 755 756 757 758 759 760 761 762 763 764 765 766 767 768 769 770 771 772 773 774 775 776 777 778 779 780 781 782 783 784 785 786 787 788 789 790 791 792 793 794 795 796 797 798 799 800 801 802 803 804 805 806 807 808 809 810 811 812 813 814 815 816 817 818 819 820 821 822 823 824 825 826 827 828 829 830 831 832 833 834 835 836 837 838 839 840 841 842 843 844 845 846 847 848 849 850 851 852 853 854 855 856 857 858 859 860 861 862 863 864 865 866 867 868 869 870 871 872 873 874 875 876 877 878 879 880 881 882 883 884 885 886 887 888 889 890 891 892 893 894 895 896 897 898 899 900 901 902 903 904 905 906 907 908 909 910 911 912 913 914 915 916 917 918 919 920 921 922 923 924 925 926 927 928 929 930 931 932 933 934 935 936 937 938 939 940 941 942 943 944 945 946 947 948 949 950 951 952 953 954 955 956 957 958 959 960 961 962 963 964 965 966 967 968 969 970 971 972 973 974 975 976 977 978 979 980 981 982 983 984 985 986 987 988 989 990 991 992 993 994 995 996 997 998 999 1000 1001 1002 1003 1004 1005 1006 1007 1008 1009 1010 1011 1012 1013 1014 1015 1016 1017 1018 1019 1020 1021 1022 1023 1024 1025 1026 1027 1028 1029 1030 1031 1032 1033 1034 1035 1036 1037 1038 1039 1040 1041 1042 1043 1044 10

JB 10/81/07

0.00



0.00

**00000000000000000000**

0.00

## Hand Finishing

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



**NOTE:** Date & initial all entries




# Work Order ID 53337

October 30, 2009 1:33:18 PM

Page 3

Item ID:	PB67-43001-173	Accept		Setup	Start	
Revision ID:	BA C <del>PB67-43001-173</del> 09.12.09				Stop	
Item Name:	Cover Plate					
Start Date:	11/2/2009	Start Qty:	10.00		Cust Item ID:	
Required Date:	11/23/2009	Req'd Qty:	10.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  Powdercoat Powder Coating	Green Sandtex(Ref:4.3.5.8) per QSI005 4.3 <i>M18441</i> Memo START TIME: <i>8:20</i> <i>320</i> <input type="checkbox"/> FINISH TIME: <i>8:50</i>	0.00  0.00							
				<i>162</i>	<i>10-01-11</i>	<i>10</i>			
170  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00							
				<i>7 M</i>	<i>10-01-11</i>	<i>(12)</i>	<i>0</i>		
180  Packaging Packaging	Identify as per dwg & Stock Location:  Memo	0.00  0.00							
				<i>N/A</i>	<i>10/19/23</i>	<i>10-12-11</i>	<i>SL</i>	<i>122</i>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 53337

October 30, 2009 1:33:18 PM



Page 4

Item ID:	PB67-43001-173	Accept		Setup	Start	
Revision ID:	BY <del>CPH</del> 09-12-09				Stop	
Item Name:	Cover Plate					
Start Date:	11/2/2009	Start Qty:	10.00			
Required Date:	11/23/2009	Req'd Qty:	10.00			
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 	QC5- Inspect part completeness to step on W/O	0.00							
QC Quality Control	Memo	0.00							
200 	PURCHASING	0.00							
Purchasing	Memo	0.00							
Purchasing	SEND TO TALMAR FOR FOAM AND FABRIC								
210 	Receive & Inspect for Damage & Mat'l Certs	0.00							
Packaging	Memo	0.00							
Packaging									

N/A  
CL 10/9/23

P/O: 12624

CL 10/9/23 (10)

CL 10/10/09 (11)

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10-10-05	170	- fulman kept 1 for sample	MF	10-10-05	1	DE 10/10/05	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**Work Order ID 53337**

October 30, 2009 1:33:18 PM

Page 5

Item ID: PB67-43001-173

Accept

Revision ID: B1 C ~~REVIEW on 12-09~~

Item Name: Cover Plate

Setup Start

Stop

Start Date: 11/2/2009 Start Qty: 10.00

Required Date: 11/23/2009 Req'd Qty: 10.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

220

QC6- Inspect dimensions to drawing

0.00

810110105



QC

Memo

0.00

Quality Control

X11

230

Identify as per dwg &amp; Stock Location: 432

0.00



Packaging

Memo

0.00

Packaging

C6410/5 (11)

240

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/10/05 JG  
MF  
10-10-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

October 30, 2009 1:33:18 PM

Page 1

Work Order ID: 53337

Parent Item: PB67-43001-173RevB1

Parent Item Name: Cover Plate

Start Date: 11/2/2009

Required Date: 11/23/2009

Comments:

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M2024T3S.032		Purchased	No			100	sf	203.3122	11.1032			



2024-T3 .032 sheet



189-12-17

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

MAT

203.3122316

102942

1.5

105555

4.0684

106272

5.3

108595

1.2

109240

7.02

110305

144

110778

18.8996316

111699

18.3242

18147

3

113189

113189

12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

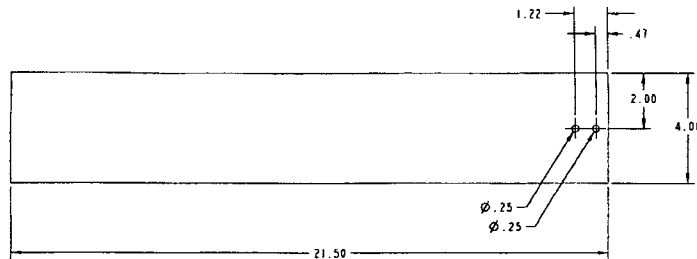
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

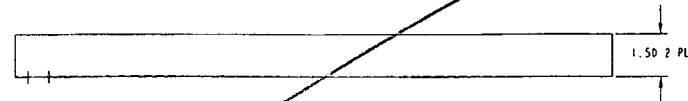


#53337

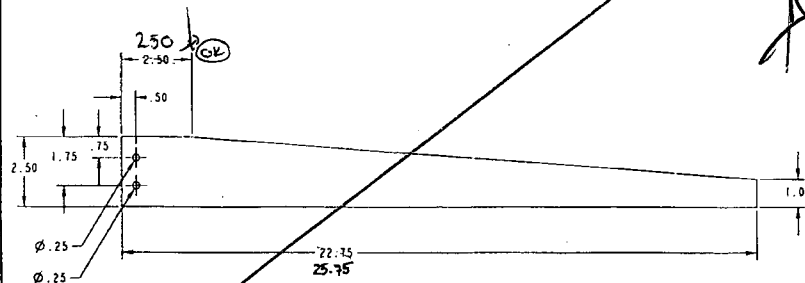
RELEASED  
1-10-70



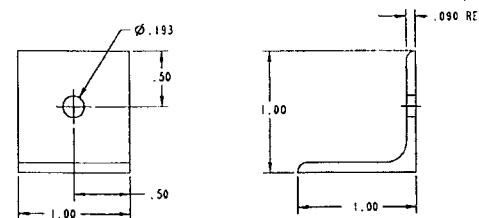
② -169 LONG SUPPORT PLATE  
MATL: .090 THK, 6061-T6, 00-A-250/11  
SCALE 0.500



② -173 COVER PLATE  
MATL: .032 THK, 2024-T3, 00-A-250/4  
SCALE 0.500



④ -167 LONG SIDE PLATE  
MATL: .125 THK, 6061-T6, 00-A-250/11  
SCALE 0.500



② -171 MOUNTING PLATE  
MATL: AND10133-1002, 6061-T6, 00-A-250/8F  
ALT MATL: .090 THK, 6061-T6, 00-A-250/11  
SCALE 2.000

PREMIER AVIATION, INC.  
3800 Aviation Parkway, Grand Prairie, Texas 75052  
FILE CODE: 1002-1002, 6061-T6, 00-A-250/8F  
D OSUV8 B67-43001  
SCALE: 1/16" = 1" 21 of 45

ORIGINAL

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

8

7

2

1

D

7.19

C

**B67-43**

B

1.50

**B67-43**

(M)

A

**NOTES:**

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.032 THICK  
PER AMS-QQ-A-250/4 OR AMS 4037  
REF. DART SPEC. M2024T3S.032
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART SPEC. M2024T3S.032  
POWDER COAT GREEN SANDTEX (4.3.5.8)
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "B67-43"
- 7) WEIGHT: 0.48 lbs

RW

**DART AEROSPACE LTD**

HAWKESBURY, ONTARIO, CANADA

DRAWING NO.

**B67-43001-173**

REV. C

SHEET 2 OF 2

TITLE

**COVER PLATE**

SCALE

NTS

COPYRIGHT © 1995 BY DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS  
NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT  
WRITTEN PERMISSION FROM DART AEROSPACE LTD.

8

7

2

1

A

B

C

D

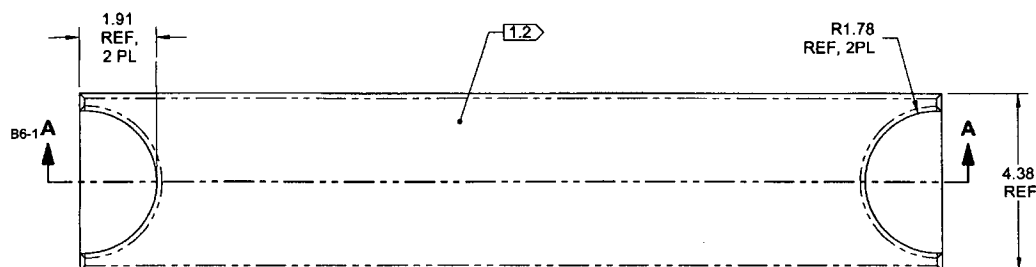
**PRELIMINARY ISSUE**

04.12.09

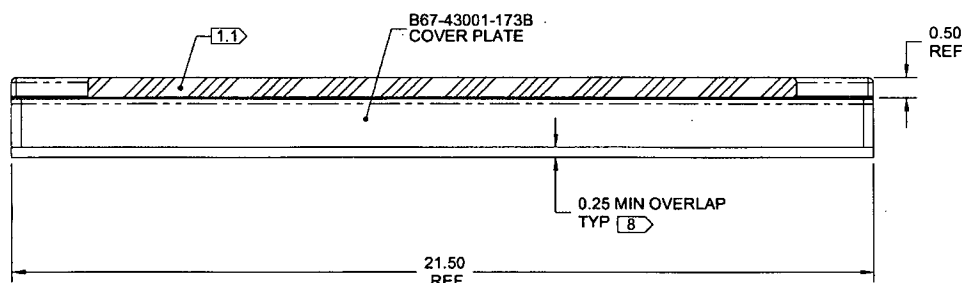
W/O ID = 53337



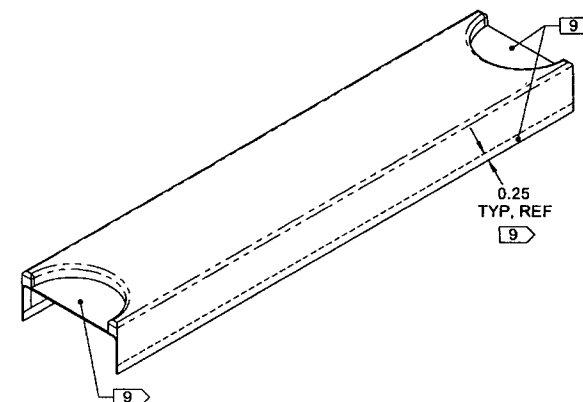
ITEM	QTY -173	P/N	DESCRIPTION
1	X	B67-43001-173	COVER PLATE ASSEMBLY
2	1	B67-43001-173B	COVER PLATE
3	A/R	1637-001	SEE NOTE 1.1
4	A/R	1495	SEE NOTE 1.2
5	A/R	LA4009	SEE NOTE 1.3



**B67-43001-173 COVER PLATE ASSEMBLY**



**SECTION A-A** D8-1



#58337

RELEASED  
R 2010-09-16 U

**NOTES:**

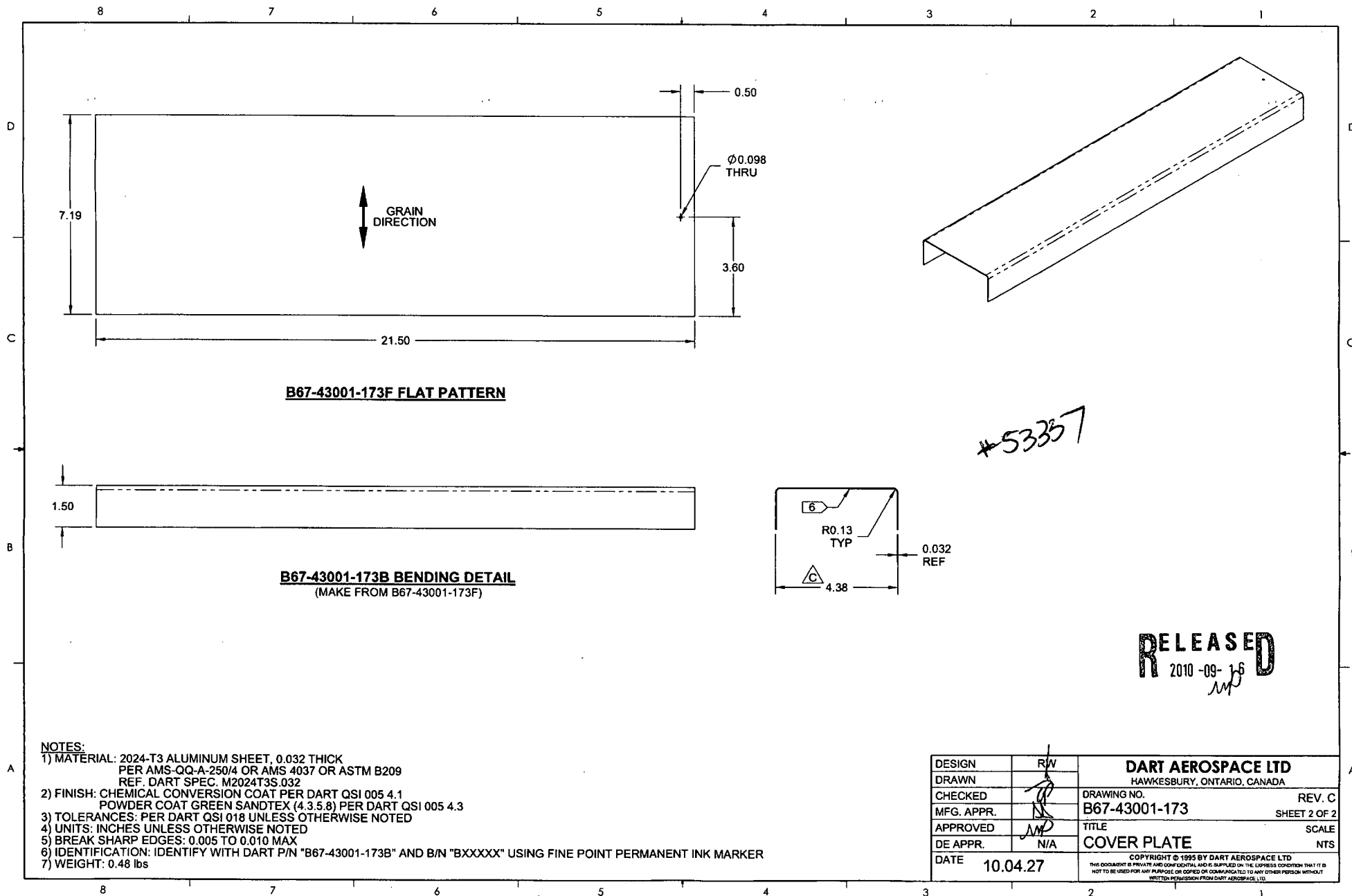
**1) MATERIAL:**

- 1.1) FOAM: ETHYLENE PROPYLENE NEOPRENE SBR CLOSED-CELL, FLAME RETARDANT, 0.50 THICK, PER ASTM D1056 2A2, SERVICE TEMP -40°F TO +200°F, COLOUR: BLACK REF. TULMAR P/N 1637-001
- 1.2) FABRIC: 100% 420 DENIER NYLON, MIN THREAD COUNT 35X35, POLYURETHANE COATED ONE SIDE, COLOUR: BLACK REF. TULMAR P/N 1495
- 1.3) ADHESIVE: URETHANE WITH CATALYST, TWO PART, CLIFTON LA4009
- 2) FINISH: BOND NEOPRENE TO COVER PLATE USING ADHESIVE. COVER WITH DENIER AS SHOWN.
- 3) TOLERANCES: PER TABLE 1 (ZN A3-1) UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.78 lbs REF
- 8) DENIER NYLON TO BE BONDED ALL AROUND INNER SIDES OF PLATE
- 9) DENIER NYLON TO BE BONDED TO PLATE ON OUTER SIDE

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018, QSI 043 AND TULMAR SAFETY SYSTEMS INC.'S MANUFACTURING PROCESS AND TOLERANCES ON FABRIC; 4.38 WAS 4.25. FOR PREVIOUS REVISIONS, REFER TO SHEETS 10 AND 27 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		MB	10.04.27
	REV.	DESCRIPTION		
	DESIGN	RW		
	DRAWN			
CHECKED		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
MFG. APPR.		DRAWING NO. B67-43001-173	REV. C	SHEET 1 OF 2
APPROVED		TITLE COVER PLATE	SCALE NTS	
DE APPR.	N/A			
DATE	10.04.27	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD		

**TABLE 1** 3

TOLERANCES ON FABRIC (PARTS AND ASSEMBLIES)	
±1/8: DIMS <2	
±1/4: DIMS 2 TO <10	
±1/2: DIMS 10 TO <20	
±5/8: DIMS 20 TO <40	
±1.5%: DIMS EQUAL TO OR > 40	



**B67-43001-173F FLAT PATTERN**

**B67-43001-173B BENDING DETAIL**  
(MAKE FROM B67-43001-173F)

#53357

RELEASED  
2010-09-18

- NOTES:**
- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.032 THICK  
PER AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209  
REF. DART SPEC. M2024T3S.032
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "B67-43001-173B" AND B/N "BXXXXX" USING FINE POINT PERMANENT INK MARKER
  - 7) WEIGHT: 0.48 lbs

DESIGN	R/W	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		B67-43001-173	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.	N/A	COVER PLATE	NTS
DATE	10.04.27	COPYRIGHT © 1995 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

# TULMAR

## PACKING SLIP COPY

Tulmar Safety Systems Inc.  
1123 Cameron Street  
Hawkesbury, ON K6A 2B8 CA  
Tel: 613-632-1282  
Fax: 613-632-2030  
MID : XOTULSAF1123HAW  
email: info@tulmar.com

Bill To:

**Dart Aerospace**  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7. Canada

Packing Slip No. **37305**  
Ship Date **4-Oct-10**

Ship to:

**Dart Aerospace**  
1270 Aberdeen Street  
Call Chantal re Pick-Up  
Tel: 613-632-9577  
Hawkesbury, ON K6A 1K7. Canada

Order number	Sales order date	Account number	Account manager	
25447	28-Sep-10	CDART100	Barney Bangs	
PO number	Ship Via	Shipping Terms		
PO12624	Pick-Up	FOB HAWKESBURY		
Item No.	Quantity ordered	UOM	Qty Shipped/Returned	Quantity on back order
Description				
8421-105	7	EA	7	1
Cover Plate, 20%/ Drawing No: B67-43001-73 DWG Rev: C Lot No: BATCH0000000005 Qty: 7				
8421-101	11	EA	11	1
D-Pad Assembly, Short/ Drawing No: B67-43001-83 DWG Rev: C Lot No: BATCH0000000008 Qty: 11				
8421-102	3	EA	3	1
D-Pad Assembly, Long/ Drawing No: B67-43001-85 DWG Rev: C **Dart to make new holes themselves Lot No: BATCH0000000006 Qty: 3				
8421-104	11	EA	11	1
Cover Plate/ Drawing No: B67-43001-173 DWG Rev: C Lot No: BATCH0000000008 Qty: 11				
8421-103	11	EA	11	1
Cover Plate/ Drawing No: B67-43001-181 DWG Rev: C Lot No: BATCH0000000006 Qty: 11				

# PACKING SLIP

# TULMAR

Tulmar Safety Systems Inc.

1123 Cameron Street  
Hawkesbury, ON K6A 2B8 CA

Tel: 613-632-1282  
Fax: 613-632-2030  
MID : XOTULSAF1123HAW  
email: info@tulmar.com

Bill To:

**Dart Aerospace**

1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7. Canada

Packing Slip No.

**37305**

Ship Date

4-Oct-10

Ship to:

**Dart Aerospace**

1270 Aberdeen Street  
Call Chantal re Pick-Up  
Tel: 613-632-9577  
Hawkesbury, ON K6A 1K7. Canada

Shipper

Ruth Andrews

Date:

4-Oct-2010

**Certificate of Conformance**

☐ Not Applicable

☐ See Certification Enclosed

I hereby certify that the items listed hereon have been inspected, and / or tested (as applicable), conform to all specifications and requirements detailed in the contract or purchase order. Objective evidence to support this statement is on file, and can be made available upon request.

If any questions or concerns, please contact QA Manager @ 613-632-1282 ext. 245.

Authorized Inspector

Roxanne Hawthorne

Date:

Oct 4/10

E.F. Walter Inc.	<b>CERTIFICAT DE CONFORMITÉ</b> <b>CERTIFICATE OF COMPLIANCE</b>		Approved <u>JR</u> Date <u>1/3/02</u>
Revision # 0	Revision date: January 30, 2002	Doc # F.7.5.5.A	Page 1 of 1

Date : 09/09/2008

VENDU À  
SOLD TO

6048

TULMAR SAFETY SYSTEMS INC.

1123 CAMERON STREET

HAWKESBURY ONT

K6A 2B8

FOURNISSEUR  
VENDOR

E.F. WALTER INC.

180 BARTOR ROAD

TORONTO, ONTARIO

M9M 2W6

Commande / Order # 14649-00

Notre / Our Reference # 55968

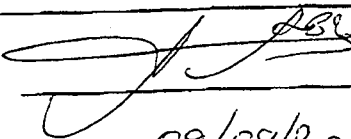
Nous certifions par la présente que la totalité du matériel inscrit ci-dessous a été inspecté et vérifié et est conforme aux devis et aux normes mentionnés sur votre commande.

We hereby certify that all of the material listed below has been inspected and tested and conforms to the drawings and / or specifications stated on your purchase order.

Item	Quantité Quantity	Pièce # Part #	Description
742050005	8.000 PCS	# 1637-001	SPONGE NEOPRENE BLACK SC42 TRIMMED NO SKIN (1/2" x 54" x 72") ASTM D1056, 2A2
			<u>810/10/05</u>
			LOT # 75570 MANUFACTURING DATE: Sept. 5, 2008

used on TSS 8421-101 (B67-43001-83)  
102 (B67-43001-85)  
103 (B67-43001-181)  
104 (B67-43001-173)  
105 (B67-43001-73)

Signé  
Signed



09/09/2008

TSS # 1637-001/02



# J. ENNIS FABRICS LTD.

Wholesale Distributor of Textiles and Supplies

March 9, 2010

Fax To: Tulmar Safety Systems  
 Fax: 613-632-2030  
 Attention: Sandra Nadeau

**EDMONTON  
 HEAD OFFICE**  
 12122 - 68 Street  
 Edmonton, AB T5B 1R1  
 Canada  
 Phone: (780) 474-5721

## Certificate of Conformance

Re: PO 17505-00 for Oxford 7 Black

The goods shipped on P/O 17505-00 are as per sampled goods. Specification as follows:  
 As per mill documentation:

Oxford 7 black is in compliance with the following standards:

**Width:** Product is 58 inches Wide.

**Roll Size:** Average Roll Length is 75 Yards.

**Weight:** Product Weight is 6.79 Ounces per Sq.Yd. /Product Weight is 10.94 oz per Lin.Yd

**Content:** 100% Nylon

**Coating:** Product has a Polyurethane Coating (approximately 0.65 oz/ Sq.Yd. (18.5g/sq.yd.))

**Denier:** Yarn is 420 Denier.

**Thread Count:** Construction is 62 x 38 Threads per Square Inch

**Protective Finish:** Product is Water Repellent.

**Hydro Resist:** AATCC 127 (Suter): Average 800 mm

Piece # 105255723, Manufacture Date: 12/30/09, Lot Number: 379360  
 Piece # 105255723, Manufacture Date: 12/30/09, Lot Number: 379360  
 Piece # 105255749, Manufacture Date: 12/30/09, Lot Number: 379360

8/10/10/05

Stc

**CALGARY**  
 2nd Floor, 337 - 17 Avenue SW  
 Calgary, AB T2S 0A5  
 Canada

**VANCOUVER**  
 13911 Bridgeport Road  
 Richmond, BC V6V 1J6  
 Canada

**MONTREAL**  
 9280 boulevard du Golf  
 Anjou, QC H1J 3A1  
 Canada

Sincerely,  
 J. Ennis Fabrics Ltd.

S. James

Sharon James  
 Product Development

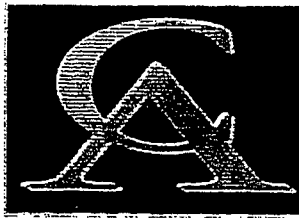
used on TSS 8421-105 (867-4300-73)  
 8421-101 (867-4300-83)  
 8421-102 (867-4300-85)  
 8421-104 (867-4300-173)  
 8421-103 (867-4300-181)

English: 1-800-66-ENNIS

Fax: (780) 479-6135  
 www.jennisfabrics.com

Français: 1-888-66-ENNIS

TSS 1495/17

**FAKED**  
*6-15-10***CLIFTON**  
**Adhesive, Inc**  
Industrial Adhesives & Coatings

Date: 6/11/10

**Certificate of Compliance**

This letter certifies that 11 x 5 gallon pails of LA4009 Adhesive,  
lot number (s) 10-145 was shipped to you on 6/11/10.

*5/10/10/05*

Clifton Adhesive, Inc manufactured this material according to internal specifications  
which include quality control and assurance procedures. The material was  
manufactured on 5/25/10 against your Purchase Order # 17863-00.

Shelf Life: 1 year from date of manufacture  
Expiration Date: 5/25/11

This letter certifies that 4 x quart cans of CATUR Accelerator,

Lot number 10-138 was shipped to you on 6/11/10.

Clifton Adhesive, Inc manufactured this material according to internal specifications  
which include quality control and assurance procedures. The material was  
manufactured on 5/18/10 against your Purchase Order # 17863-00.

Shelf Life: 6 months from date of manufacture  
Expiration Date: 11/18/10

Sincerely,

*Dan Constantino*

Daniel Constantino  
Quality Assurance Mgr/ISO Coordinator



48 Burgess Place • Wayne, NJ 07470 USA  
Phone: 973-694-0845 • Fax: 973-694-5678  
[www.cliftonadhesive.com](http://www.cliftonadhesive.com)

used on TSS 8421-101 (B67-43001-83)  
102 (B67-43001-85)  
103 (B67-43001-181)  
104 (B67-43001-173)  
105 (B67-43001-731)

*TSS 7/22/37**(S)*



**American & Efid Inc.**  
**Post Office Box - 507**  
**Mount Holly, NC -28120**

### Test Report

Date : 9/17/2010

Mfg. Date : 3/27/2010

Quantity: 43

Lot Id : 705150

Product : Tex 90 BONDED 'Z' NYLON FILAMENT Black AA 63002 16 OZ

Specification : A-A-59826 TPII CLA F BT92N4

Customer Order Number : 17499-00

Plys (Visual) : 4

Twist Direction : Z

Customer : Tulmar Safety Inc.

A&E Color : 63002 Black  
AA

Shipped To : Tulmar Safety Inc.

Description : Bright, Continuous Multifilament Nylon, Melting Point >472F; Colorless Nylon Polymer Bond; Polypropylene Spools

Characteristic	Test1	Test2	Test3	Test4	Test5	Average	Minimum	Maximum
Strength #1 (Pound)	15.2	15.7	15.6	15.7	15.8	15.619		
Strength #2 (Pound)	15.4	15.1	15.2	15.4	14.8	15.177		
Average Strength (Pound)						15.4	11.8	

Elongation #1 (Percent)	20.5	22.4	21.8	22	21.8	21.722		
Elongation #2 (Percent)	22.3	21.4	21.9	22.5	21.1	21.856		
Average Elongation (Percent)						21.8		26

Lube

Pass Pass

Twist S #1 (Turns per inch)	12.2	12.2	12.2	12.2	12.2	12.2		
Twist S #2 (Turns per inch)	12.2	12.2	12.2	12.2	12.2	12.2		
Average Twist S (Turns per inch) Initial Twist						12.2		

Twist Z #1 (Turns per inch)	8.1	8.1	8.1	8.1	8.1	8.1		
Twist Z #2 (Turns per inch)	8.1	8.1	8.1	8.1	8.1	8.1		
Average Twist Z (Turns per inch) Final Twist						8.1	5.5	

Yield #1 (Yards/Pound)	4211.8		4211.8					
Yield #2 (Yards/Pound)	4114.7		4114.7					
Average Yield (Yards/Pound)			4163.2	3601	5200			

Laundry #1 (Grading Scale)	5		5					
Laundry #2 (Grading Scale)	5		5					
Average Laundry (Grading Scale)			5	3				

used on TSS 8421-101 (067-43001-83)

TSS #2530/48



Dry Cleaning #1 (Grading Scale)	5	5	
Dry Cleaning #2 (Grading Scale)	5	5	
Average Dry Cleaning (Grading Scale)		5	3
Perspiration #1 (Grading Scale)	5	5	
Perspiration #2 (Grading Scale)	5	5	
Average Perspiration (Grading Scale)		5	3
Color Fastness to Light #1 (Grading Scale)	5	5	
Color Fastness to Light #2 (Grading Scale)	5	5	
Average Color Fastness to Light (Grading Scale)		5	3.4

I certify that the above test were performed under my supervision and in accordance with the specification test requirements and that the reported test results are true, valid and applicable to the samples tested. I further certify that these samples were the only samples tested from the lot of components identified above.

Signed :

*Joseph D. Munday*

Joseph D. Munday  
Testing Director

Note:

This Certificate of Compliance is the property of American & Efird Inc. and may not be reproduced except in it's entirety.

TS # 2530/48 (S)



# J. ENNIS FABRICS LTD.

*Wholesale Distributor of Textiles and Supplies*

March 9, 2010

**Fax To: Tulmar Safety Systems**  
**Fax: 613-632-2030**  
**Attention: Sandra Nadeau**

**EDMONTON**  
**HEAD OFFICE**  
 12122 - 68 Street  
 Edmonton, AB T5B 1R1  
 Canada  
 Phone: (780) 474-5721

## Certificate of Conformance

**Re: PO 17505-00 for Oxford 7 Black**

The goods shipped on P/O 17505-00 are as per sampled goods. Specification as follows:  
 As per mill documentation:

**Oxford 7 black** is in compliance with the following standards:

**Width:** Product is 58 inches Wide.

**Roll Size:** Average Roll Length is 75 Yards.

**Weight:** Product Weight is 6.79 Ounces per Sq.Yd. /Product Weight is 10.94 oz per Lin.Yd

**Content:** 100% Nylon

**Coating:** Product has a Polyurethane Coating {approximately 0.65 oz/ Sq.Yd. (18.5g/sq.yd.)}

**Denier:** Yarn is 420 Denier.

**Thread Count:** Construction is 62 x 38 Threads per Square Inch

**Protective Finish:** Product is Water Repellent.

**Hydro Resist:** AATCC 127 (Suter): Average 800 mm

**Piece # 105255723, Manufacture Date: 12/30/09, Lot Number: 379360**

**Piece # 105255723, Manufacture Date: 12/30/09, Lot Number: 379360**

**Piece # 105255749, Manufacture Date: 12/30/09, Lot Number: 379360**

Stc

**TORONTO**  
 6300 Kenway Drive  
 Mississauga, ON L5T 2N3  
 Canada

**CALGARY**  
 2nd Floor, 337 - 17 Avenue SW  
 Calgary, AB T2S 0A5  
 Canada

**VANCOUVER**  
 13911 Bridgeport Road  
 Richmond, BC V6V 1J6  
 Canada

**MONTREAL**  
 9280 boulevard du Golf  
 Anjou, QC H1J 3A1  
 Canada

Sincerely,  
**J. Ennis Fabrics Ltd.**

*S. James*

Sharon James  
 Product Development

used on TSS 8421-105 (867-43001-73)  
 8421-101 (867-43001-83)  
 8421-102 (867-43001-85)  
 8421-104 (867-43001-173)  
 8421-103 (867-43001-181)

English: 1-800-66-ENNIS

Fax: (780) 479-6135  
 www.jennisfabrics.com

Français: 1-888-66-ENNIS

TSS 1495/17

Dry Cleaning #1 (Grading Scale)	5
Dry Cleaning #2 (Grading Scale)	5
Average Dry Cleaning (Grading Scale)	

5	
5	
5	3

Perspiration #1 (Grading Scale)	5
Perspiration #2 (Grading Scale)	5
Average Perspiration (Grading Scale)	

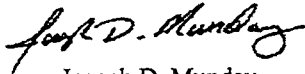
5	
5	
5	3

Color Fastness to Light #1 (Grading Scale)	5
Color Fastness to Light #2 (Grading Scale)	5
Average Color Fastness to Light (Grading Scale)	

5	
5	
5	3.4

I certify that the above test were performed under my supervision and in accordance with the specification test requirements and that the reported test results are true, valid and applicable to the samples tested. I further certify that these samples were the only samples tested from the lot of components identified above.

Signed :



Joseph D. Munday  
Testing Director

Note

This Certificate of Compliance is the property of American & Efird Inc. and may not be reproduced except in its entirety.

BS # 2530/48 (S)

E.F. Walter Inc.	<b>CERTIFICAT DE CONFORMITÉ CERTIFICATE OF COMPLIANCE</b>		Approved <u>JR</u> Date <u>1/3/02</u>
Revision # 0	Revision date: January 30, 2002	Doc # F.7.5.5.A	Page 1 of 1

VENDU À  
SOLD TO

6048

TULMAR SAFETY SYSTEMS INC.  
1123 CAMERON STREET  
HAWKESBURY ONT  
K6A 2B8

Date : 09/09/2008

FOURNISSEUR  
VENDOR

E.F. WALTER INC.  
180 BARTOR ROAD  
TORONTO, ONTARIO  
M9M 2W6

Commande / Order # 14649-00

Notre / Our Reference # 55968

Nous certifions par la présente que la totalité du matériel inscrit ci-dessous a été inspecté et vérifié et est conforme aux devis et aux normes mentionnés sur votre commande.

We hereby certify that all of the material listed below has been inspected and tested and conforms to the drawings and / or specifications stated on your purchase order.

Item	Quantité Quantity	Pièce # Part #	Description
742050005	8.000 PCS	# 1637-001	SPONGE NEOPRENE BLACK SC42 TRIMMED NO SKIN (1/2" x 54" x 72") ASTM D1056, 2A2
			LOT # 75570 MANUFACTURING DATE: Sept. 5, 2008

used on TSS 8421-101 (B67-43001-83)  
102 (B67-43001-85)  
103 (B67-43001-181)  
104 (B67-43001-173)  
105 (B67-43001-73)

Signé  
Signed

09/09/2008

Ten # 1127 001 1A7